

Work Order ID 84159

84159

Page 1

May-04-12 2:14:55 PM

Item ID: D4464-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Tank Assembly

Start Date: 04/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/05/04* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4464

C

100

Weld per dwg A/R Aluminum rod Batch: *119785*
120854 0.00

1000

Large Fab

Large Fab

Memo

0.00

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4463-11 as per dwg D4464

2- Weld D4001-1 and D4000-5 onto D4463-1 Top

2- Weld D4463-9 and D4463-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg. Weld D4463-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4463-7 fwd end

PURGE INSIDE OF TANK

1 *0* *12.05.07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 18/05/2012 Req'd Qty: 1.00 ***1***

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				1	0	3E12/05/07	
120 *120* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>120854</u> Memo I-Weld top D4463-1 ***PURGE INSIDE OF TANK***	0.00 0.00				1	0	hl 12-05-08	
123 *123* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo ***Pressure Test as per dwg D4464***	0.00 0.00				0			

- filled tank w/water tested with TACC powder 12-05-08
- after paint tested to 4.5 psi and soapy water 12-05-11
- filled w/water and air pressure to 4.5 psi 12-05-11

Done after 1.5 psi

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140 QC9- Inspect visual per QSI004- Fusion Welds 0.00

140

QC

Memo

0.00

Quality Control

1 0 BE 12/05/08

150 Chemical Conversion Coat per QSI005 4.1 0.00

150

HandFinish

Memo

0.00

Hand Finishing

1- brush alodine on tank. No alodine inside

IX 0 M-L 12/05/09

160 QC7-Inspect Chemical Conversion Coat 0.00

160

QC

Memo

0.00

Quality Control

1x 0 M n l o s i g t

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Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170									
Powdercoat		0.00							
Powder Coating									
	Memo								
	Mask prior to powdercoat								
	POWDER COAT ANSI 61 GREY AS PER DWG AND QSI 005 4.3								
	Start Time: 11:20								
	Oven Temperature: 320°F								
	Finish Time: 1:50								
180	QC3- Inspect Part Finish	0.00							
180									
QC		0.00							
Quality Control									
	Memo								
190		0.00							
190									
Small Fab		0.00							
Small Fab									
	Memo								
	Assemble as per dwg and for D4577-041/-3/-5 access panels install with proseal								
	890								
	A/R proseal 890 Batch: 112/287								

M118533

1X 12/05/09

1 12-59

1X 12/05/10

W/O: 84159



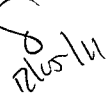


WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4464-041 PAR #: _____ Fault Category: Design NCR: Yes No DQA: init Date: 12/05/28
 Resolution: Rework Disposition: Rework QA: N/C Closed: UK Date: 12/5/28

NCR: 17-1426

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12.05.10	190	M535206-266 ARE STRIPPING/DEFORMING/ PHILLIPS CROSS HEAD DETACHING PROWINGERS	 12.05.10 OS1042	REPLACE QT7(4) M535206- 266 WITH AN3-6A BOLTS B/W: <u>M113359</u>	 12/5/10	 12/05/11	 12.05.10 OS1042	 12/5/11
		RC: SCREWS ARE TOO LONG / NOT APPROPRIATE.						

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Required Date: 18/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

210

Identify as per dwg & Stock Location:

0.00

210

Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

(4)

12/4/11 (1)

12/5/14

ME
12-05-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 04/05/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A 11.11.23 NEW ISSUE DD VERF:EC
12.03.08 AS PER DWG REV.B DD VERF:EC
ECN 12-571 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-5 *D3997-5* Placard		Manufactured	No			190	Each	16.0000	2	2			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST141				106					
				72611				84					
				81028				10					
				83650				12					
D3997-11 *D3997-11* Placard		Manufactured	No			190	Each	15.0000	1	1			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST141				15					
				80308				3					
				82957				12					
D3997-17 *D3997-17* Placard		Manufactured	No			190	Each	17.0000	1	1			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST141				17					
				80309				5					
				82958				12					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 04/05/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3997-29

Manufactured No

190

Each

18.0000

1

1

D3997-29

Placard

**

Location

Loc Qty

Loc Code

ST141

18

80845

18

D3997-43

Manufactured No

190

Each

15.0000

1

1

D3997-43

Placard

**

Location

Loc Qty

Loc Code

ST141

15

80310

3

82960

12

D3999-7

Manufactured No

100

Each

9.0000

1

1

D3999-7

Corner

**

Location

Loc Qty

Loc Code

WA014

9

71695

1

75156

8

D3999-9

Manufactured No

100

Each

8.0000

1

1

D3999-9

Angle

**

Location

Loc Qty

Loc Code

WA014

8

71696

1

82545

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 04/05/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3999-11

Manufactured No

100

Each

2.0000

1

1

D3999-11

Earth Tab

**

12.05.07

Location

Loc Qty

Loc Code

WA

B84161

8

WA013

-8

WA014

2

75180

2

D4000-1

Manufactured No

100

Each

13.0000

1

1

D4000-1

Fuel Supply Fitting

**

12.05.07

Location

Loc Qty

Loc Code

WA

80029

13

83811

1

12

D4000-5

Manufactured No

100

Each

11.0000

1

1

D4000-5

Fuel Tank Vent Fitting

**

12.05.07

Location

Loc Qty

Loc Code

WA013

80030

11

83813

1

10

D4000-9

Manufactured No

100

Each

14.0000

3

3

D4000-9

Grommet

**

12.05.07

Location

Loc Qty

Loc Code

WA013

78379

6

WA014

83814

6

8

8

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 84159

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D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 04/05/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

D4000-045

Manufactured No

100

Each

7.0000

1

1

D4000-045

Fuel Pickup Fitting Assembly

**

12.05.08

Location

Loc Qty

Loc Code

WA

1

81071

1

WA013

5

72078

1

82696

4

WA014

1

71669

1

D4008-11

Manufactured No

100

Each

12.0000

1

1

D4008-11

Hinge Half

**

12.05.05

Location

Loc Qty

Loc Code

WA

12

80037

4

80838

8

D4008-041

Manufactured No

190

Each

5.0000

1

1

D4008-041

Fuel Filler Splash Guard Assembly

**

12/05/10

Location

Loc Qty

Loc Code

ST142

5

78910

3

82599

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 04/05/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

D4023-3 Manufactured No

190

Each

10.0000

1

1

D4023-3

Cap and Flange

**

12.05.05

Location

Loc Qty

Loc Code

ST084

6

81898

6

ST110

1

73514

1

WA

3

80032

3

D4025-5 Manufactured No

190

Each

8.0000

1

1

D4025-5

Fuel Quantity Sender

**

12/05/10

Location

Loc Qty

Loc Code

ST141a

8

76894

2

81899

6

D4057-1 Manufactured No

100

Each

36.0000

3

3

D4057-1

Retaining Ring

**

12.05.07

Location

Loc Qty

Loc Code

WA013

36

71166

3

81889

9

83656

24

D4062-041 Manufactured No

190

Each

0.0000

1

1

D4062-041

Tank Support Assembly

**

83821

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D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 04/05/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

D4124-1

Manufactured No

100 Each

37.0000

4 4

D4124-1

**

Tab

Location

Loc Qty

Loc Code

WA

37

76895

7

83824

30

D4125-1

Manufactured No

100 Each

7.0000

1 1

D4125-1

**

Sump

Location

Loc Qty

Loc Code

WA

7

81151

1

83825

6

D4125-3

Manufactured No

100 Each

7.0000

1 1

D4125-3

**

End

Location

Loc Qty

Loc Code

WA

7

81152

1

83826

6

D4404-3

Manufactured No

100 Each

5.0000

1 1

D4404-3

**

Cushion, Side

Location

Loc Qty

Loc Code

ST242A

5

76898

5

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Parent Item Name: Fuel Tank Assembly

Start Date: 04/05/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

D4404-5 Manufactured No

100 Each 10.0000 4 4

D4404-5

Cushion, Fwd

**

12/05/10

Location

Loc Qty

Loc Code

ST242A

10

76899

1

80753

9

4

D4462-1 Manufactured No

100 Each 6.0000 1 1

D4462-1

Baffle

**

12.05.07

Location

Loc Qty

Loc Code

WA

6

83827

6

D4462-3 Manufactured No

100 Each 4.0000 1 1

D4462-3

Baffle

**

12.05.07

Location

Loc Qty

Loc Code

WA

4

83828

4

D4463-041 Manufactured No

120 Each 1.0000 1 1

D4463-041

Tank Top Assembly

**

12.05.07

Location

Loc Qty

Loc Code

WA

1

83829

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Fuel Tank Assembly

Start Date: 04/05/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

D4463-3 Manufactured No

100 Each 4.0000 1 1

D4463-3

Tank Aft End

**

12.05.07

Location

Loc Qty

Loc Code

WA

4

83833

4

D4463-5 Manufactured No

100 Each 12.0000 1 1

D4463-5

Tank Upper Cut Out

**

12.05.07

Location

Loc Qty

Loc Code

WA

12

83834

12

D4463-7 Manufactured No

100 Each 4.0000 1 1

D4463-7

Tank Fwd End

**

12.05.07

Location

Loc Qty

Loc Code

WA001

4

83836

4

D4463-9 Manufactured No

100 Each 4.0000 1 1

D4463-9

Tank Back

**

12.05.07

Location

Loc Qty

Loc Code

WA001

4

83837

4

D4463-11 Manufactured No

100 Each 2.0000 1 1

D4463-11

Tank Front

**

12.05.05

Location

Loc Qty

Loc Code

WA001

2

83830

2

May-04-12 2:15:02 PM

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 84159

84159

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 04/05/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

D4463-13

Manufactured No

190

Each

7.0000

1

1

D4463-13

Tank Bottom

**

M 12.05.05

Location

Loc Qty

Loc Code

WA

7

82237

2

83831

5

AN3H5A

Purchased

No

190

Each

47.0000

5

5

AN3H5A

Bolt

**

EP 12/05/10

Location

Loc Qty

Loc Code

ST351

47

118112

1

120693

46

MS21042L3

Purchased

No

190

Each

3,017.000

4

4

MS21042L3

Nut

**

EP 12/05/10

Location

Loc Qty

Loc Code

ST300

3017

117441

16

117885

32

118451

5

118927

3

119017

1131

119075

138

121349

698

121444

994

4

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 10

Work Order ID: 84159

84159

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 04/05/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS35206-266

Purchased

No

190

Each

96.0000

4

4

MS35206-266

Screw

**

Location

Loc Qty

Loc Code

ST294

96

119850

96

NAS1149D0363J

Purchased

No

190

Each

3,098.000

37

37

NAS1149D0363.J

Washer

**

Location

Loc Qty

Loc Code

ST298

3098

117601

61

118077

1

118612

18

119537

33

120142

41

120308

17

120644

232

121243

1195

121524

1500

AN3-4A

Purchased

No

190

Each

704.0000

24

24

AN3-4A

Bolt

**

Location

Loc Qty

Loc Code

ST350

704

102832

88

104291

4

104625

234

117317

98

120308

80

120770

200

PTO

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Page 10

W/O: 84159

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4464-041 PAR #: _____ Fault Category: Small Tab NCR: Yes No DQA: 12/12 Date: 12/05/23
 Resolution: Rework Disposition: Rework QA: N/C Closed: 12/5/23 Date: 12/5/23

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
1205.10		AN3H5A BOLTS TOO SHORT TO USE WITH NAS1149D0363) W/ H605 RC: DESIGN.	<u>1205.10</u> <u>GS1042</u>	REPLACE QTY (5) NAS1149D0363) WITH NAS1149D0332J BIN: 1119717	<u>12/05/20</u>	<u>12/05/24</u>	<u>1205.10</u> <u>GS1042</u>	<u>12/05/24</u>

NOTE: Date & initial all entries

Picklist Print

May-04-12 2:15:02 PM

Page 11

Work Order ID: 84159

84159

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 04/05/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

D4577-1

Manufactured No

190

Each

0.0000

1

1

D4577-1

Rear Access Panel

D4577-3

Manufactured No

190

Each

0.0000

1

1

D4577-3

Middle Access Panel

D4577-041

Manufactured No

190

Each

0.0000

1

1

D4577-041

Fwd Access Panel Assembly

B 83839 **

B 83840 **

B 83838 **

Ep 12/05/10
Ep 12/05/10
Ep 12/05/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4464-041	FUEL TANK ASSEMBLY
2	2	D3997-5	PLACARD "AUX FUEL DRAIN"
3	1	D3997-11	PLACARD "LOADING"
4	1	D3997-17	PLACARD "STOWAGE"
5	1	D3997-29	PLACARD "WARNING"
6	1	D3997-43	PLACARD "EARTH"
7	1	D3999-7	CORNER
8	1	D3999-9	ANGLE
9	1	D3999-11	EARTH TAB
10	1	D4000-1	FUEL SUPPLY FITTING
11	1	D4000-5	FUEL TANK VENT FITTING
12	3	D4000-9	GROMMET
13	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
14	1	D4008-11	TANK HINGE HALF
15	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
16	1	D4023-3	FUEL CAP
17	1	D4025-5	FUEL SENDER
18	3	D4057-1	RETAINING RING
19	1	D4062-041	TANK SUPPORT ASSEMBLY
20	4	D4124-1	TAB
21	1	D4125-1	FWD SEDIMENT BOWL
22	1	D4125-3	AFT SEDIMENT BOWL
23	1	D4404-3	CUSHION, SIDE
24	4	D4404-5	CUSHION, FWD
25	1	D4462-1	BAFFLE
26	1	D4462-3	BAFFLE
27	1	D4463-041	TOP TANK ASSEMBLY
28	1	D4463-3	TANK AFT END
29	1	D4463-5	TANK UPPER CUT OUT
30	1	D4463-7	TANK FORWARD END
31	1	D4463-9	TANK BACK
32	1	D4463-11	TANK FRONT
33	1	D4463-13	TANK BOTTOM
34	1	D4577-041	FWD ACCESS PANEL ASSEMBLY
35	1	D4577-1	REAR ACCESS PANEL
36	1	D4577-3	MIDDLE ACCESS PANEL
37	24	AN3-4A	BOLT
38	5	AN3H5A	BOLT
39	4	MS21042L3	NUT
40	4	MS35207-266	SCREW
41	37	NAS1149D0363J	WASHER

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 04159 MLJ

12/05/04

RELEASED
2012-04-24

C	UPDATED -041 WITH RE-DESIGNED D4463-11/-13 REV. C PARTS, ZN 85-2. UPDATED -041 WITH RE-DESIGNED D4577-041/-3/-5 PARTS, ZN C6-2	DC	12.03.27
B	UPDATED -041 WITH RE-DESIGNED PARTS. REMOVED D4463-13. ADDED D4577-041/-1/-5 ACCESS PANELS, ZN C6-2.	DC	11.12.14
A	NEW ISSUE. REF PAR11-117 & CAR 11-54.	DC	11.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.03.27		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4464	REV. C SHEET 1 OF 5
TITLE TANK ASSEMBLY	SCALE NTS
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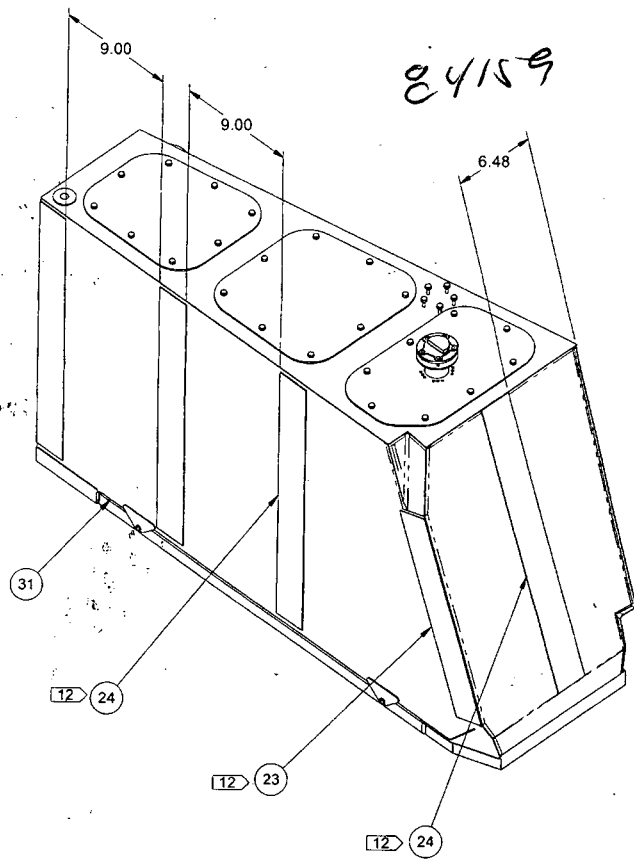
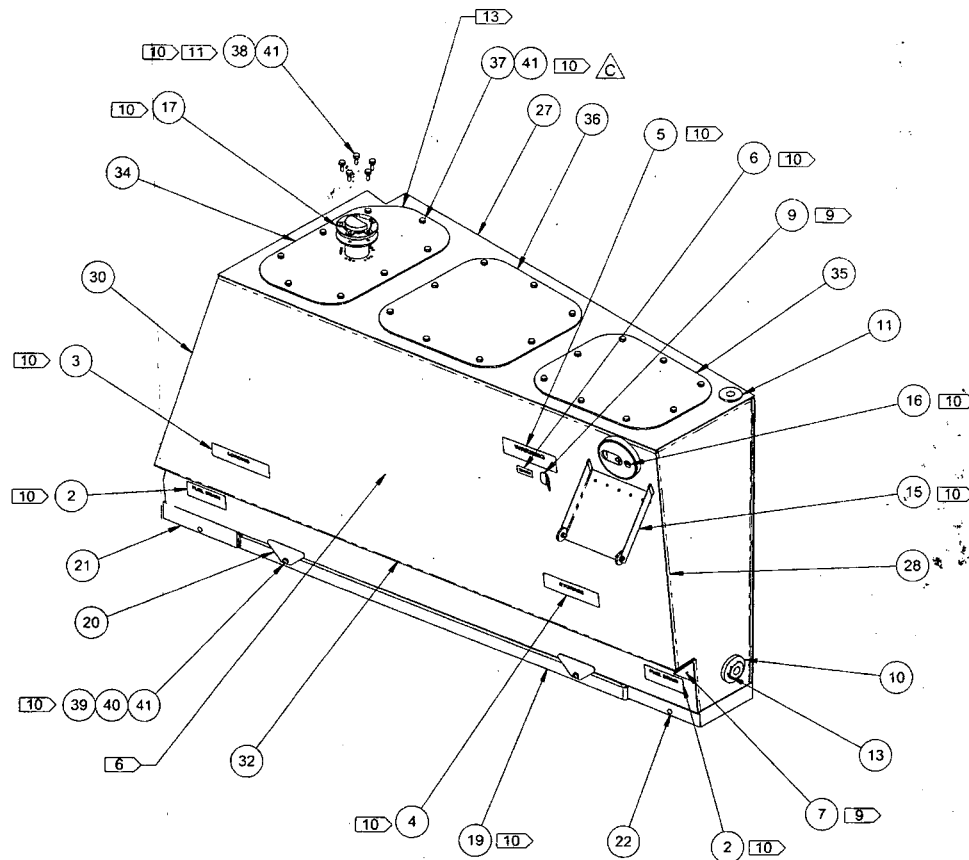
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: TOUCH UP, CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-141" USING D2729-1 RED DECAL
- 7) WEIGHT: 35.81 lbs
- 8) CAP ALL TANK ACCESS POINTS AND PRESSURE TEST TANK PER QSI 038 4.3. VERIFY NO LEAKS
- 9) MASK PRIOR TO POWDER COAT
- 10) INSTALL AFTER POWDER COAT
- 11) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 12) INSTALL CUSHIONS AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED
- 13) INSTALL D4577-041/-3/-5 ACCESS PANELS WET WITH PROSEAL 890.

D4464-041 FUEL TANK ASSEMBLY

RELEASED
2012-04-24

DESIGN		DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	BC	D4464	SHEET 2 OF 5
APPROVED	AD	TITLE	SCALE
DE APPR.	AD	TANK ASSEMBLY	NTS
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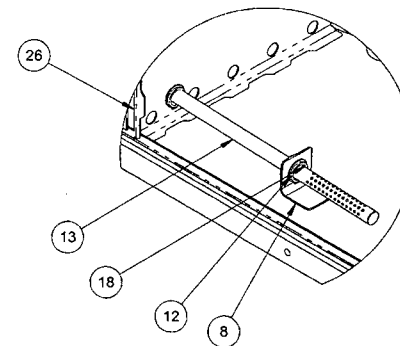
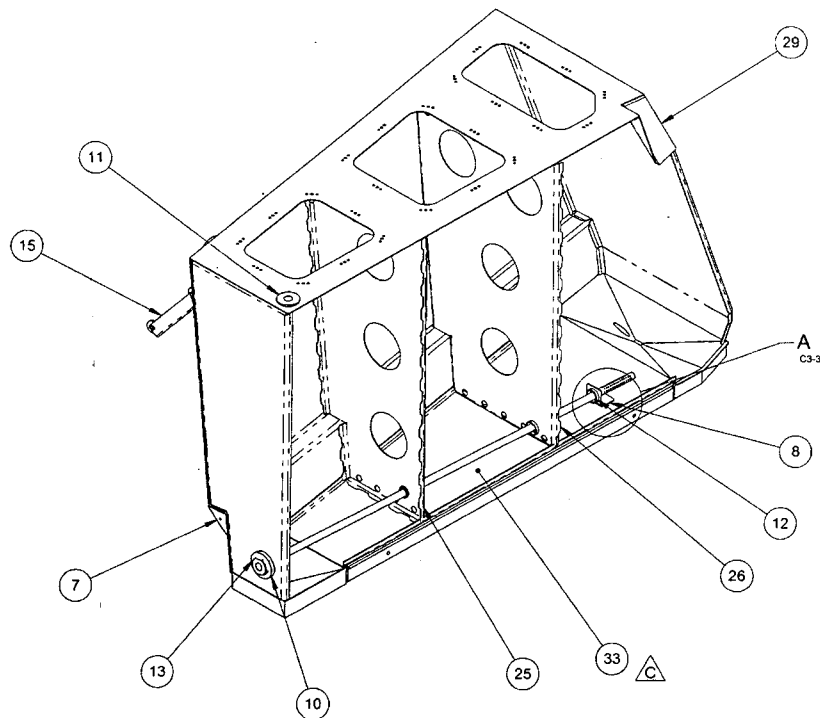
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84159



DETAIL A
ROTATED FOR CLARITY
SCALE 2X
B6-3

D4464-041 FUEL TANK ASSEMBLY
D4463-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL

RELEASED
2012-04-24
MD

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4464	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TANK ASSEMBLY	NTS
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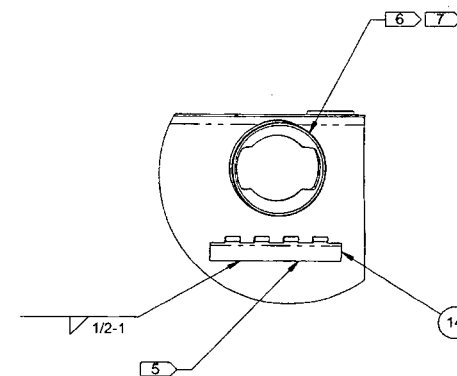
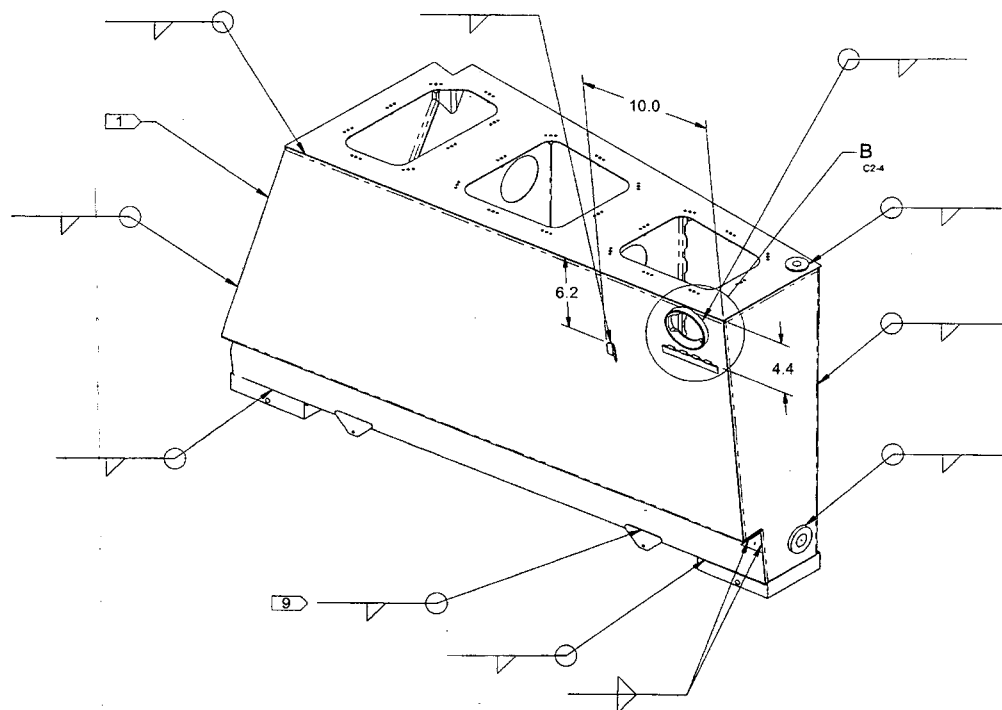
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL B
ROTATED FOR CLARITY
SCALE 2X
C2-4

D4464-041 FUEL TANK ASSEMBLY
WELDING DETAIL

NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
 - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
 - ALL SWarf REMOVED
- 3) ACCEPTABLE TO DRILL 6 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 4) ACCEPTABLE TO DRILL 7 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) CENTER HINGE BELOW FUEL CAP FLANGE
- 6) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 7) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
- 8) WELD PER DART QSI 004
- 9) USE THE D4062-041 TANK SUPPORT ASSEMBLY TO POSITION THE D4124-1 TABS BEFORE WELDING

RELEASED
2012-04-24

DESIGN	<i>BC</i>	DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>BC</i>	D4464	SHEET 4 OF 5
APPROVED	<i>MA</i>	TITLE	SCALE
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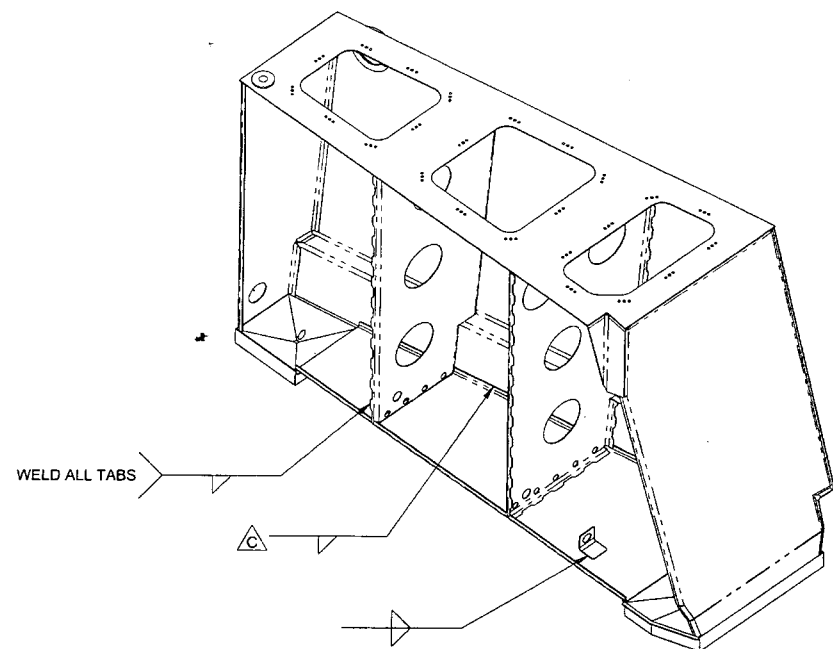
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NOTE: Date & initial all entries

84159



D4464-041 FUEL TANK ASSEMBLY
WELDING DETAIL

2012-04-24

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4464	SHEET 5 OF 5
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